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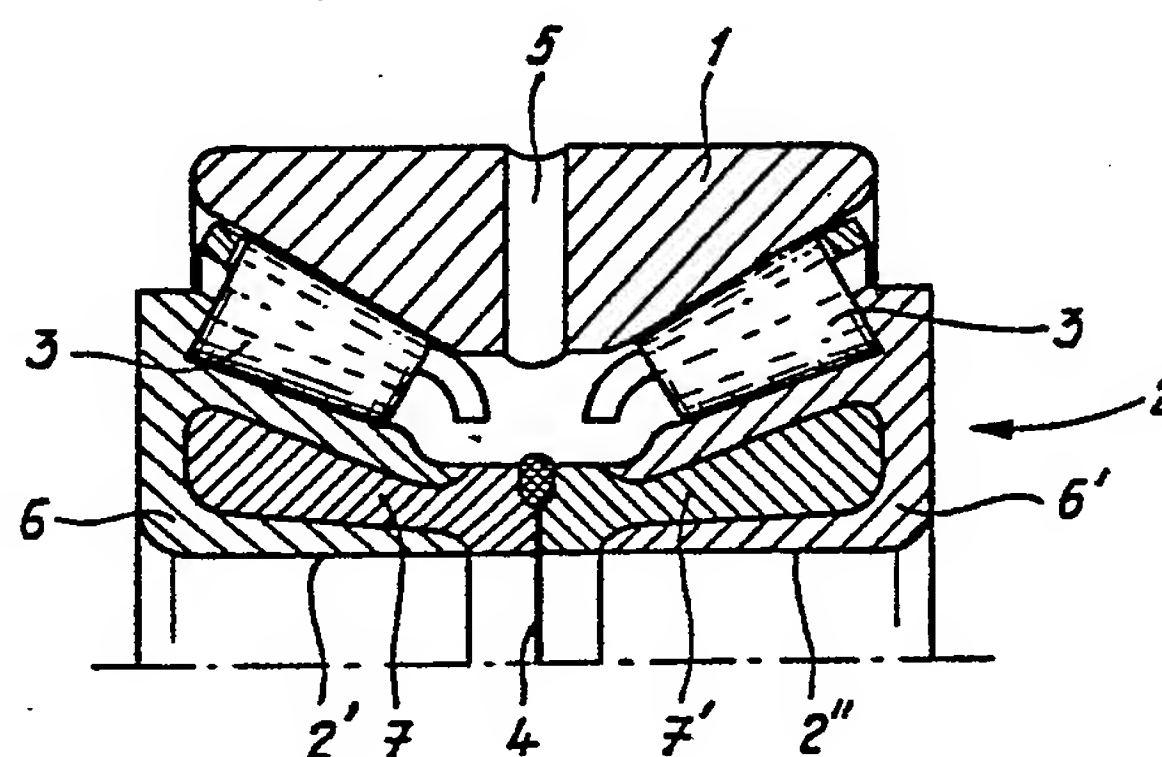
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54 Method of producing an object, in particular a rolling bearing, consisting of at least two moving parts locked into each other.

57 Welding of two bearing race-ring parts by electron beam has revealed the disadvantage that the seam becomes hard and brittle which can introduce cracks or the like defects. This disadvantage is obviated by the claimed process according to which the region (7, 7') bordering upon the seam (4) of the bearing ring parts (2, 2') are shielded during the surface hardening process. The shielding of these region (7, 7') is effected by applying on them a coating of copper or by an immersion process.

fig-1



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Method of producing an object, in particular a rolling bearing, consisting of at least two moving parts locked into each other

The invention relates to a method of producing an object consisting of at least two parts movable relative to each other, one of which parts or a portion thereof is locked essentially into the other part, in particular a rolling bearing in which at least one row of rolling elements is locked in between the two parts in the form of races, one of the parts being composed of at least two separate pieces of steel subjected to a hardening process, said pieces being placed against each other in proper position relative to the other part, where in particular the rolling elements are likewise inserted and the parts held in this position, a high-energy radiation welding means such as a laser or electron beam is placed over the parting line between the two parts and put into operation, while a rotary motion of the energy beam and the two parts held against each other is brought about relative to each other for welding the two parts together. Such a method is disclosed in U.S. Patent 3,586,396.

It has been found that the seam obtained by this method becomes hard and brittle, which is a serious disadvantage of the method.

By the process according to the invention, the seam is prevented from becoming hard and brittle by subjecting the steel pieces to a surface hardening in which the regions of the pieces bordering upon the seam are shielded from the hardening operation, so that these regions are not hardened.

Preferably the surface hardening is effected by carbon cementation or by nitro cementation.

In this way, the welding zone is not carbon cemented and consequently remains composed of soft steel with a comparatively low carbon content, so that the weld remains tough and strong.

Advantageously, the shielding of the said regions is achieved by applying a coat of copper or by slurry immersion.

It is noted that a process as mentioned above for producing a rolling bearing with two rows of rolling elements is essentially known likewise from U.S. Patent 4,419,816, where, in an integral outer race, an opening is made that, in assembled condition of the parts of the other race, is located opposed to the parting seam, and the high-energy radiation welding means is placed over the outside end of this opening so that the energy beam reaches the seam through said opening, the two parts of the inner race being jointly set in rotation.

The invention will be illustrated in more detail with reference to the drawing, in which

Fig. 1 shows a roller bearing with taper rollers, produced according to the invention, and

Fig. 2 shows a ball bearing with two rows of balls, produced according to the invention.

As shown in Fig. 1, the roller bearing produced by the method of the invention comprises an outer race 1 and an inner race 2 made of two pieces 2', 2". Between the outer race 1 and the inner race 2, two rows of taper rollers 3 are locked in. In the outer race 1, an opening 5 is made, through which the electron beam of the high-energy radiation welding means is aimed at the weld 4 upon assembly of the bearing, as described in the said U.S. Patent 4,419,816.

As shown, the parts 2' and 2" of the inner race 2, before they are welded together, are so subjected to a surface hardening operation that a hardened surface region 6, 6' and an unhardened region 7, 7', therefore still consisting of soft steel, are obtained, so that the weld 4 is located in a zone of the unhardened portion 7, 7'.

The ball bearing of Fig. 2 comprises an outer race 8 and an inner race 9 consisting of two pieces 9' and 9", between which races two rows of balls 10 are locked in, held in cages 11. In the outer race 8, as before, an opening 12 is made, for the same purpose as the opening 5 in Fig. 1. Furthermore, on either side of said opening 12, two annular plates 13 and 14 are fixed to the inside of the outer race 8, serving to keep spatters from landing within the parts of the bearing when parts 9' and 9" of the inner race are welded together at the seam 15, as described in the cited patent.

Here again, the parts 9' and 9" of the inner race 9, before they are welded together, are so subjected to a surface hardening that a hardened surface region 16, 16' and an unhardened region 17, 17', therefore still consisting of soft steel, are obtained, so that the weld 15 is located in a zone of the unhardened portion 17, 17'.

Claims

1. Method of producing an object consisting of at least two parts movable relative to each other, one of which parts or a portion thereof is essentially locked inside the other part, in particular a rolling bearing wherein, between the two parts, in the form of races, at least one row of rolling elements is enclosed, one of said parts consisting of at least two separate pieces of steel subjected to a hardening operation, where these pieces are placed against each other in proper position relative to the other part, where in particular the rolling elements are inserted and the parts are held in that

position, a high-energy radiation welding means such as a laser or electron beam is passed over the parting seam between the two parts and put into operation, while a rotary motion of the energy beam and the two parts held together relative to each other is brought about to weld the two pieces together, characterized in that the steel pieces (2', 2"; 9', 9") are subjected to a surface hardening with the regions of said pieces bordering upon the parting seam shielded from the hardening process, so that these regions (7, 7'; 17, 17') are not hardened.

2. Method according to claim 1, characterized in that the surface hardening is effected by carbon cementation.

3. Method according to claim 1, characterized in that the surface hardening is effected by nitro cementation.

4. Method according to claims 1 to 3, characterized in that the shielding of the said regions is effected by applying a coating of copper.

5. Method according to claims 1 to 3, characterized in that the shielding of the said regions is effected by slurry immersion.

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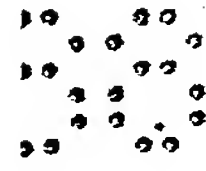


fig-1

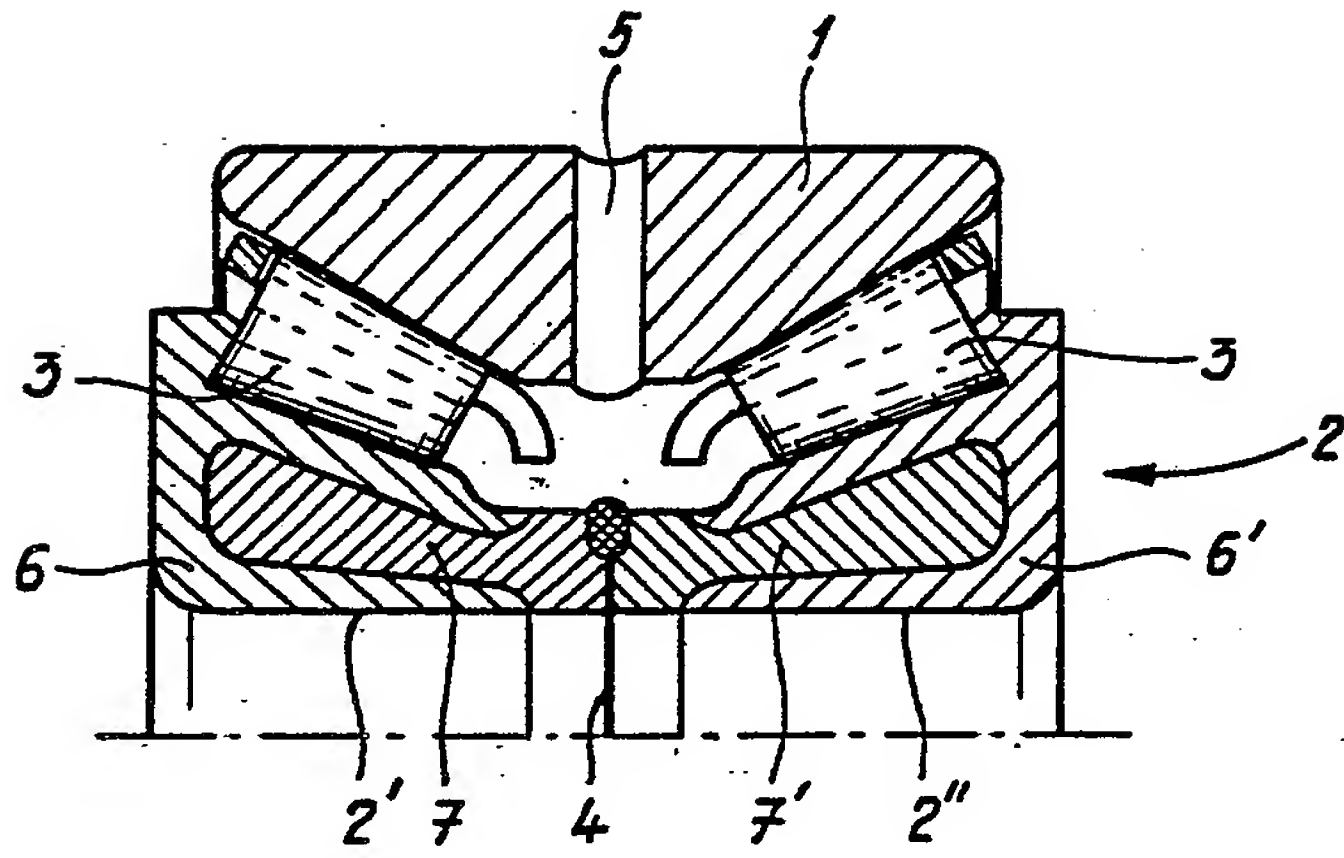
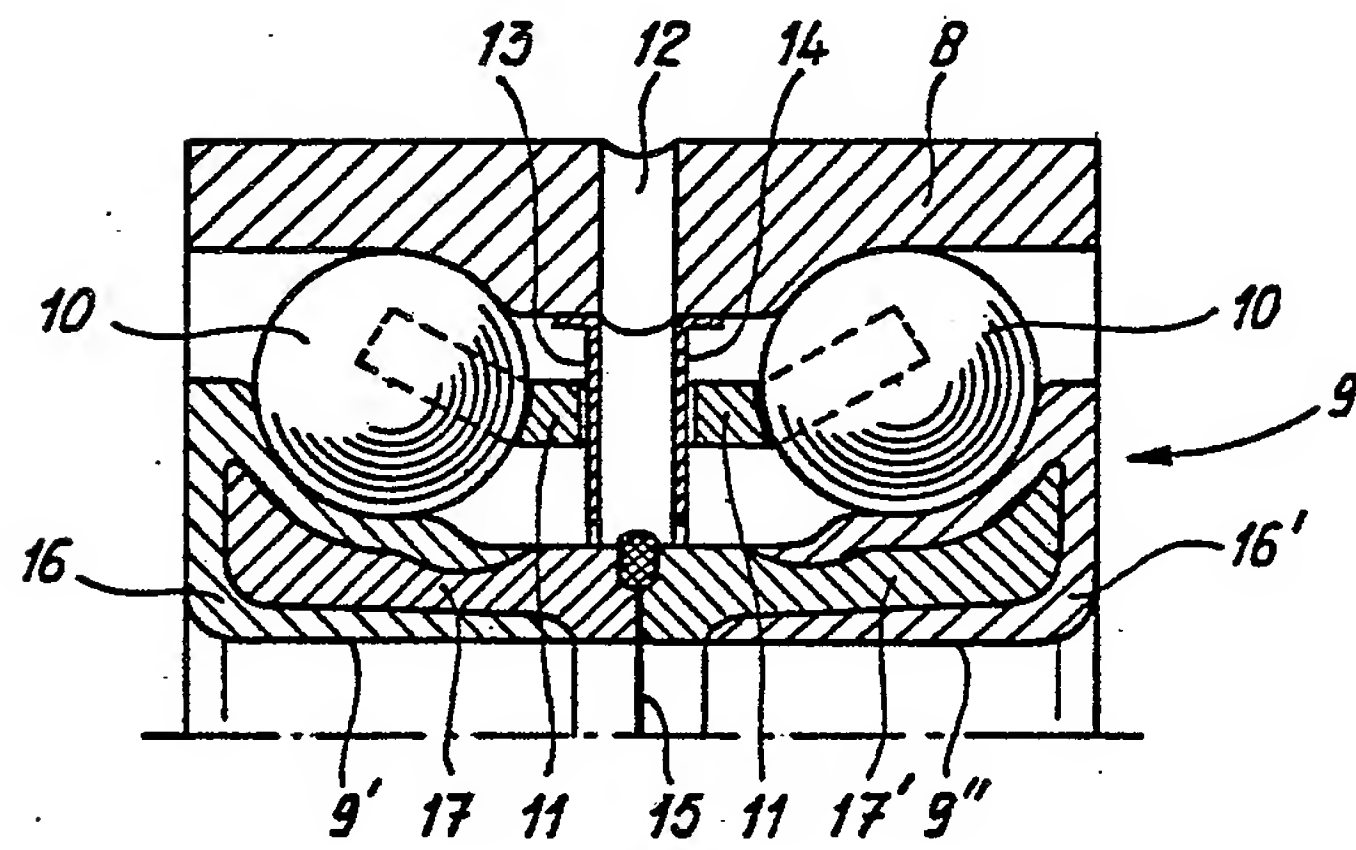


fig-2





European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 88 20 0963

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
Y,D	US-A-4 419 816 (KAPAAN) * Whole document *	1	F 16 C 33/64 F 16 C 33/60
Y	FR-A-2 082 718 (R.K.S. PASQUIER) * Page 1, lines 19-21; page 2, line 23 - page 3; claim 2 *	1	
A	FR-A-2 141 295 (FORMMET) * Page 15 *	1	
A	FR-A- 558 473 (CHARVIN) * Page 1, lines 35-36 *	2	
A	US-A-3 592 519 (MARTIN)		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			F 16 C B 23 K
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 22-08-1988	Examiner ORTHLIEB CH.E.
<div>CATEGORY OF CITED DOCUMENTS</div> <div>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</div> <div>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</div>			

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object, in particular a
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ABSTRACT:

CHG DATE=19990617 STATUS=O> Welding of two bearing race-ring parts by electron beam has revealed the disadvantage that the seam becomes hard and brittle which can introduce cracks or the like defects. This disadvantage is obviated by the claimed process according to which the region (7, 7 min) bordering upon the seam (4) of the bearing ring parts (2, 2 min) are shielded during the surface hardening process. The shielding of these region (7, 7 min) is effected by applying on them a coating of copper or by an immersion process.